

# Work Order ID 113347

February-12-14 11:25:17 AM

D 4775-041  
B 113347

\*113347\*

Page 1

Item ID: D4775-041

Revision ID:

Item Name: Strut Assembly

Start Date: 2/12/14 Start Qty: 10.00

Required Date: 2/12/14 Req'd Qty: 10.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: WLS Date: 14-02-13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4775	C
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110	Pick Kit	0.00
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\*110\*

Packaging	Memo	0.00
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Packaging

DAS  
32  
9.96

14/2/20 (9)

120		0.00
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\*120\*

Small Fab	Memo	0.00
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Small Fab

1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG

A/R PROSEAL BATCH: 127662

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

7

FF  
14-02-20



# Work Order ID 113347

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**\*113347\***

Page 2

Item ID: D4775-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Strut Assembly  
 Start Date: 2/12/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 2/12/14 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00				7			
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

140	Identify as per dwg & Stock Location: <b>SD 64</b>	0.00				7x			
<b>*140*</b>									
Packaging	Memo	0.00							
Packaging									

DAS  
26  
9-89

150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

**14-02-21**



# Picklist Print

February-12-14 9:55:12 AM

Page 1

Work Order ID: 113347  
Parent Item: D4775-041  
Parent Item Name: Strut Assembly

Start Date: 2/12/14  
Start Qty: ~~10.00~~ 9  
Required Date: 2/12/14  
Required Qty: 10.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.08.26 PB1 DD  
VERF:JLM IPP REV:C 13.09.26 AS PER REV.B DD VERF:JLM  
IPP REV:D 14.01.10 AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1 Strut Tube		Manufactured	No			110	Each	0.0000	1	10-9	FF	14-02-20	
						B 111598							
D4777-1 Rod End Bearing		Manufactured	No			110	Each	29.0000	1	10-9	DAS 32		
											9-89		
				<u>Location</u>		<u>Loc Qty</u>					<u>Loc Code</u>		
				ST123		29							
				110971		13					110971		
				112383		16							
D4776-1 Basket Strut Clevis		Manufactured	No			110	Each	13.0000	1	10-9	DAS 32		
											9-89		
				<u>Location</u>		<u>Loc Qty</u>					<u>Loc Code</u>		
				ST123		13							
				110934		13					110934		
D4776-5 Spacer		Manufactured	No			110	Each	32.0000	4	4036	111610	74	DAS 32 9-89
				<u>Location</u>		<u>Loc Qty</u>					<u>Loc Code</u>		
				ST123		32							
				111095		32					111095	294	
AN3-10A Bolt		Purchased	No			110	Each	170.0000	2	2018	DAS 32 9-89	14/2/20	
				<u>Location</u>		<u>Loc Qty</u>					<u>Loc Code</u>		
				ST351		20							
				m125709		20					m125709	164	
				ST511		150							
				m127817		150					m127817	24	

# Picklist Print

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Page 2

Work Order ID: 113347

Parent Item: D4775-041

Parent Item Name: Strut Assembly

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 10.00

Required Qty: 10.00

MS21042L3	Purchased	No	110	Each	4,086.0000	2	20 18	DAS
Nut								32
								9.85

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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ST314	131	
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M127304	90	
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M127831	41	
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ST506	955	
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123900	955	
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ST509	3000	
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M127410	3000	
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MS21209-F615

Purchased No

110 Each 17.0000

Heli-Coil

1	10 9	DAS
		32
		9.85

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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GA	12	
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125097	12	
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ST319	5	
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m128199	5	
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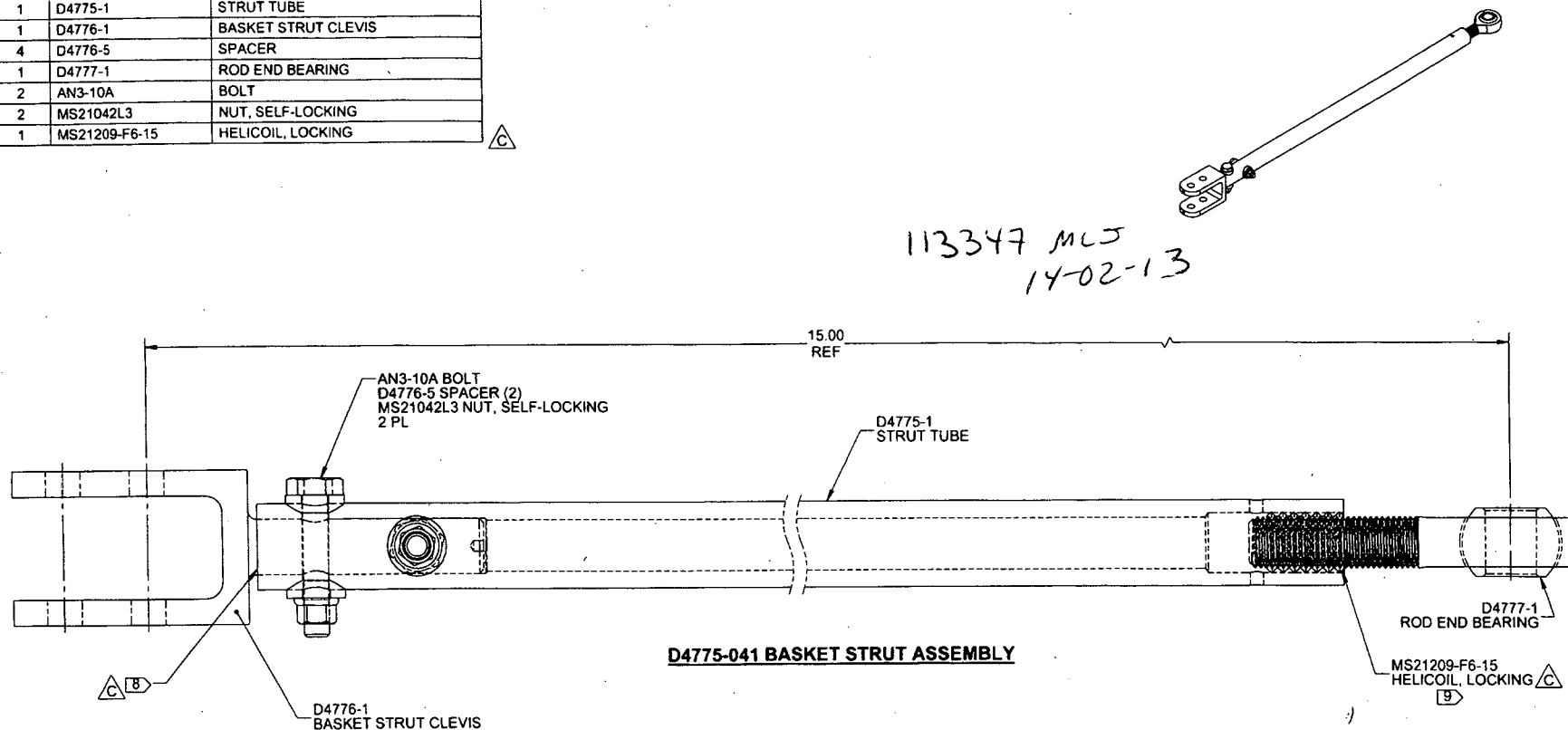
m127410

4

m128199

14/2/20 (9)

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4775-041	BASKET STRUT ASSEMBLY
1	1	D4775-1	STRUT TUBE
2	1	D4776-1	BASKET STRUT CLEVIS
3	4	D4776-5	SPACER
4	1	D4777-1	ROD END BEARING
5	2	AN3-10A	BOLT
6	2	MS21042L3	NUT, SELF-LOCKING
7	1	MS21209-F6-15	HELICOIL, LOCKING



**D4775-041 BASKET STRUT ASSEMBLY**

**NOTES:**

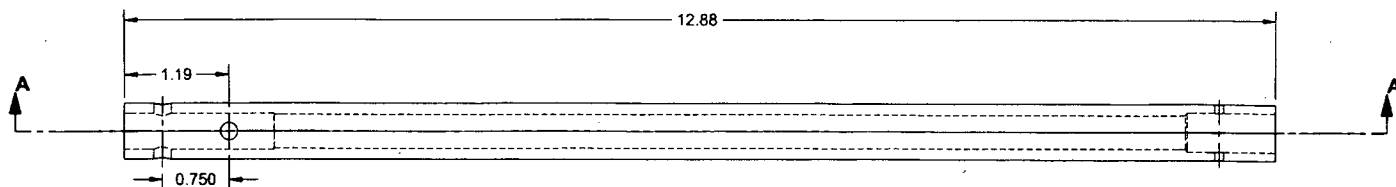
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.45 lbs
- 8) APPLY PROSEAL 890 B-2 (PRC) TO THE STEM OF ITEM 2 TO PREVENT RATTLING.
- 9) ENSURE HELICOIL DOES NOT BLOCK HOLE

RELEASED  
2014-01-07

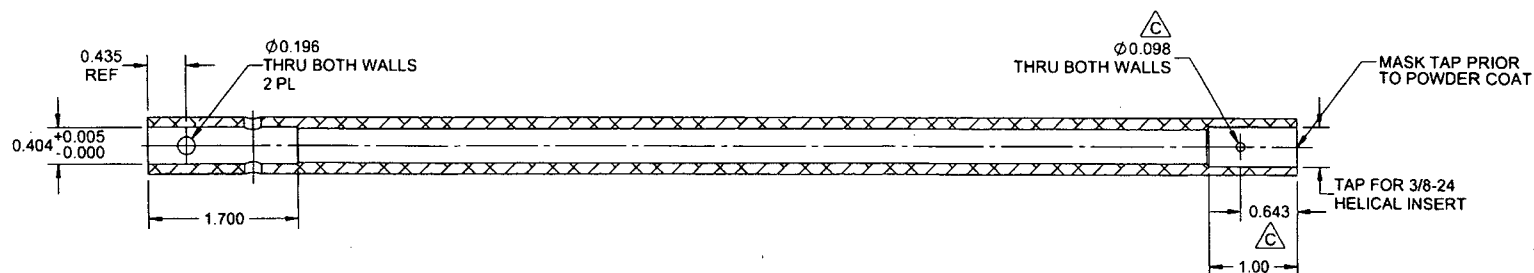
C	ITEM 7 WAS F6-20, B2-2 Ø0.098 "WITNESS HOLE" ADDED. REASON: CUSTOMER FEEDBACK. ADDED NOTE 8. REASON: DESIGN IMPROVEMENT.	AJS	13.11.01
B	DELETED WELD PINS (-3) REPLACED WITH FASTENERS. REASON: PREVENT CRACKING & EASE OF MANUFACTURE. C6-2 HOLE PATTERN ON -1 REVERSED TO ENSURE FASTENERS CLEAR STRUCTURE. FINISH NOTE MOVED TO -1 (SHEET 2).	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4775</b> <b>BASKET STRUT ASSEMBLY</b> <small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	AJS		
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.		REV. C SHEET 1 OF 2 SCALE NTS	
DATE	13.11.01		







**D4775-1 STRUT TUBE**



**SECTION A-A**

RELEASED  
2014-01-08  
WJ

**NOTES:**

- 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING,  $\Phi 0.625 \times 0.125$  WALL  
PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8  
OR AMS 4080 OR AMS 4082 OR AMS 4083  
OR ASTM B210 OR ASTM B241  
REF DART SPEC M6061T6T0.625W0.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		<b>D4775</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET STRUT ASSEMBLY</b>	NTS
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